

Date: Wednesday, 11/02/2009 7:03:28 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL LOCK
Job Number : 45740	
Estimate Number : 12342	
P.O. Number :	Part Number : D3368041
This Issue : 11/02/2009 S.O. No. :	Drawing Number : D3368 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 43419	Material :
Written By :	Due Date : 18/02/2009 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est Rev:A Removed from 9 Digit 06-03-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33681	Pedal Lock Base
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3368-1 BASE B44255

2.0	D33683	Pedal Lock Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3368-3 COVER B44256

3.0	D27287	Dart Logo label
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Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Decal B22554

4.0	D33737	Cam Lock
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3373-7 Cam Lock B22167

CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE

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Job Number: 45740

Part Number: D3368041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D33853	Hinge
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3385-3	Hinge	B22387

EP09/02/11

6.0	238028	3/16" Dowel Pin .5" long
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	238-028	Ø3/16" Dowel Pin 1/2" long	M17278

EP09/02/11

7.0	385039	8-32 Flat screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	385-039	Flat Head Screw	M107150

EP09/02/10

8.0	D33841	Cyclic Sock
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3384-1	Cyclic Sock	B37170 (R) B45752 (5x)

EP09/02/10

9.0	CBL460	Loop Sleeve
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CBL-460	Loop Sleeve	M109062

EP09/02/10

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Part Number: D3368041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	CBL1240	Cable
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Comment: Qty.: 2.3333 f(s)/Unit Total : 11.6665 f(s)

Pick:

Qty	Part Number	Description	Batch
28"	CBL-1240	Cable	M103927

EP09/02/10

11.0	AN960416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960-416	Washer	M19356

EP09/02/10

12.0	HX81	1/4"-20 SHCS 3/8" long
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	HX-81	1/4"-20 SHCS 3/8" long	M16971

EP09/02/10

13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel.
Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-5

3-Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Ensure mechanism works properly (open/close).

Pick:

Qty	Part Number	Description	Batch
A/RN/A	262 Locktite		M110005

4-Assemble lanyard to cyclic sock as per Dwg D3384

5-Assemble D3384-047 to D3368-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3368

6-Ensure that keys are attached to D3368-041

EP09/03/10 ⑥

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 09/03/18 (x6)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST484

SS 09/03/20 (x6)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 (x6)

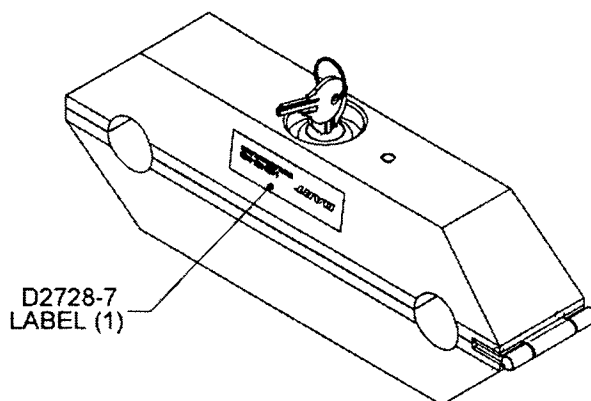
Job Completion



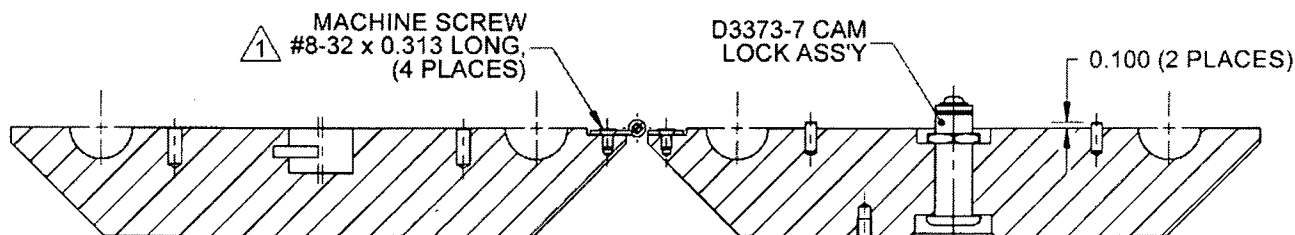
mf 09-03-23

DART

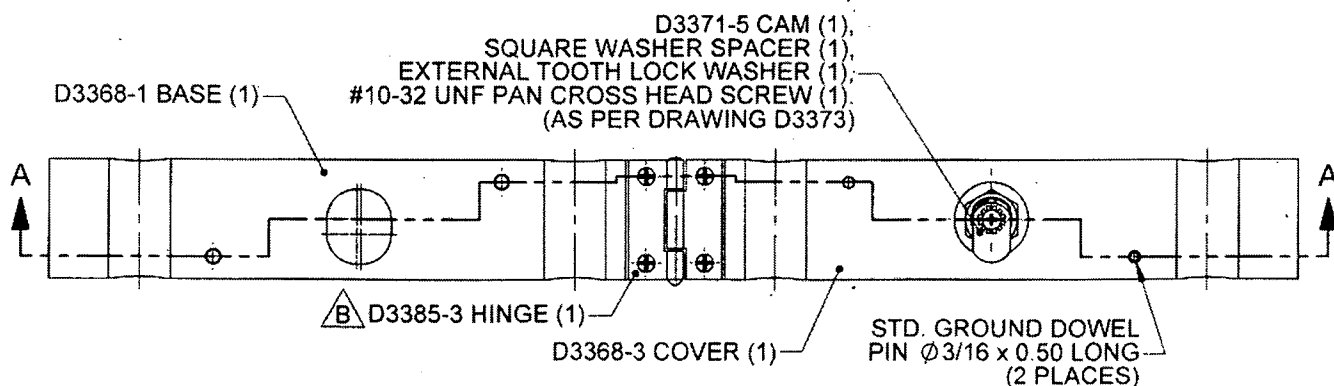
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

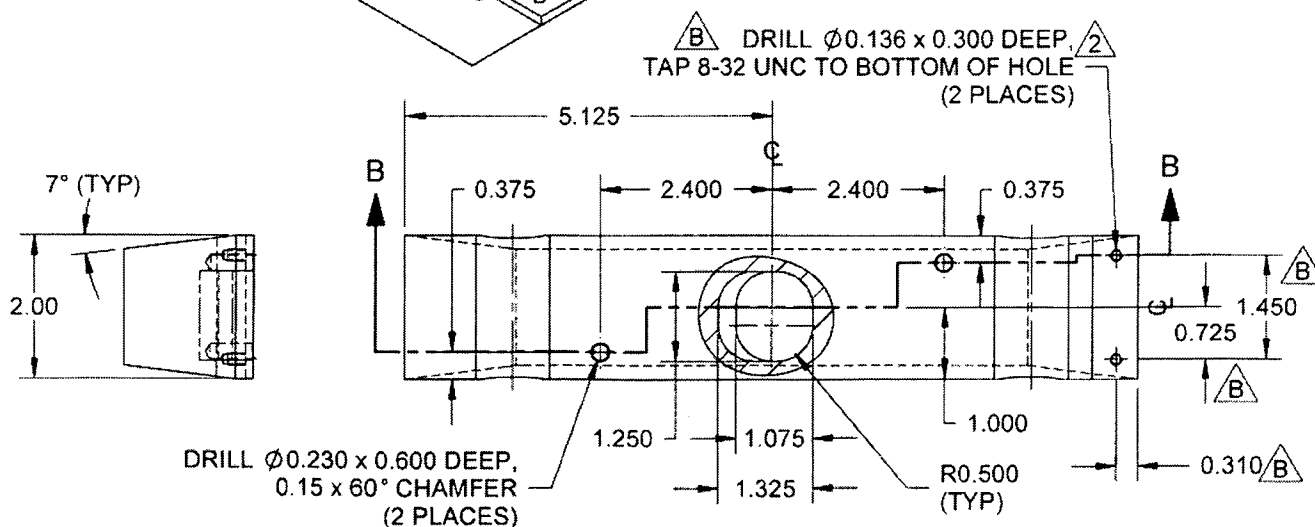
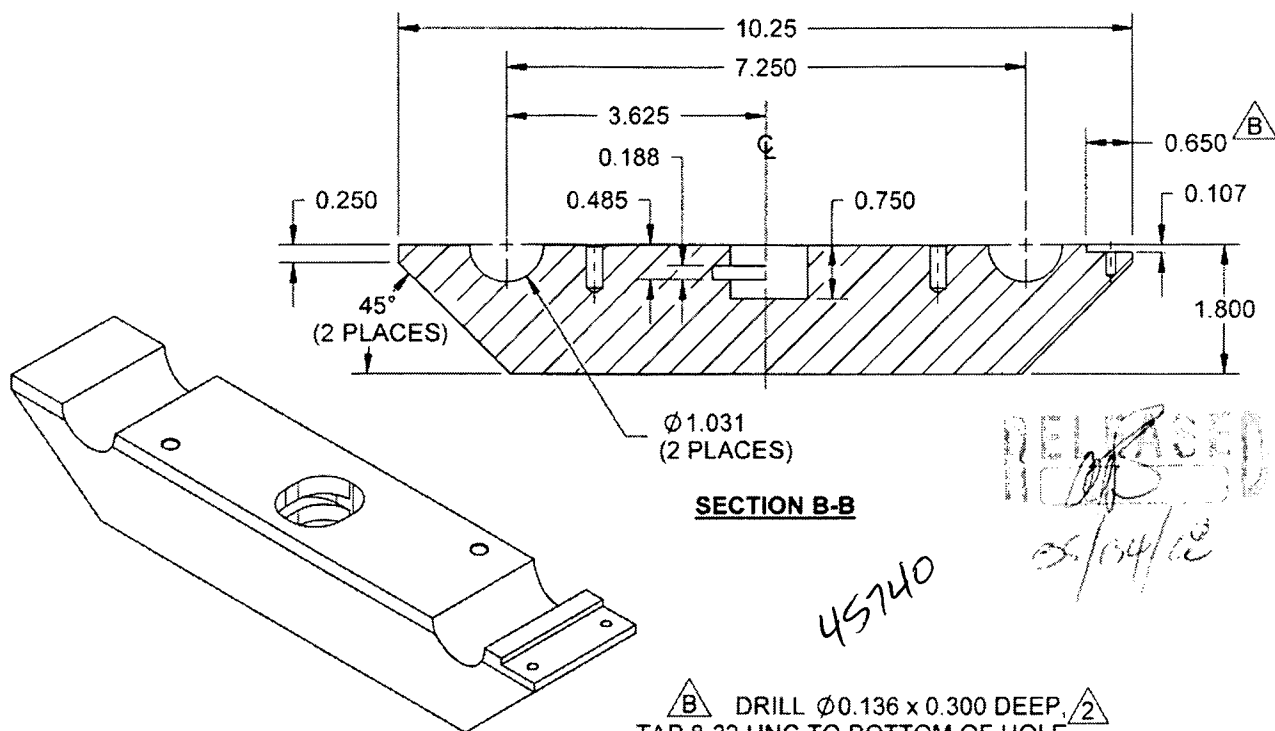
- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



D3368-1 BASE

NOTES:

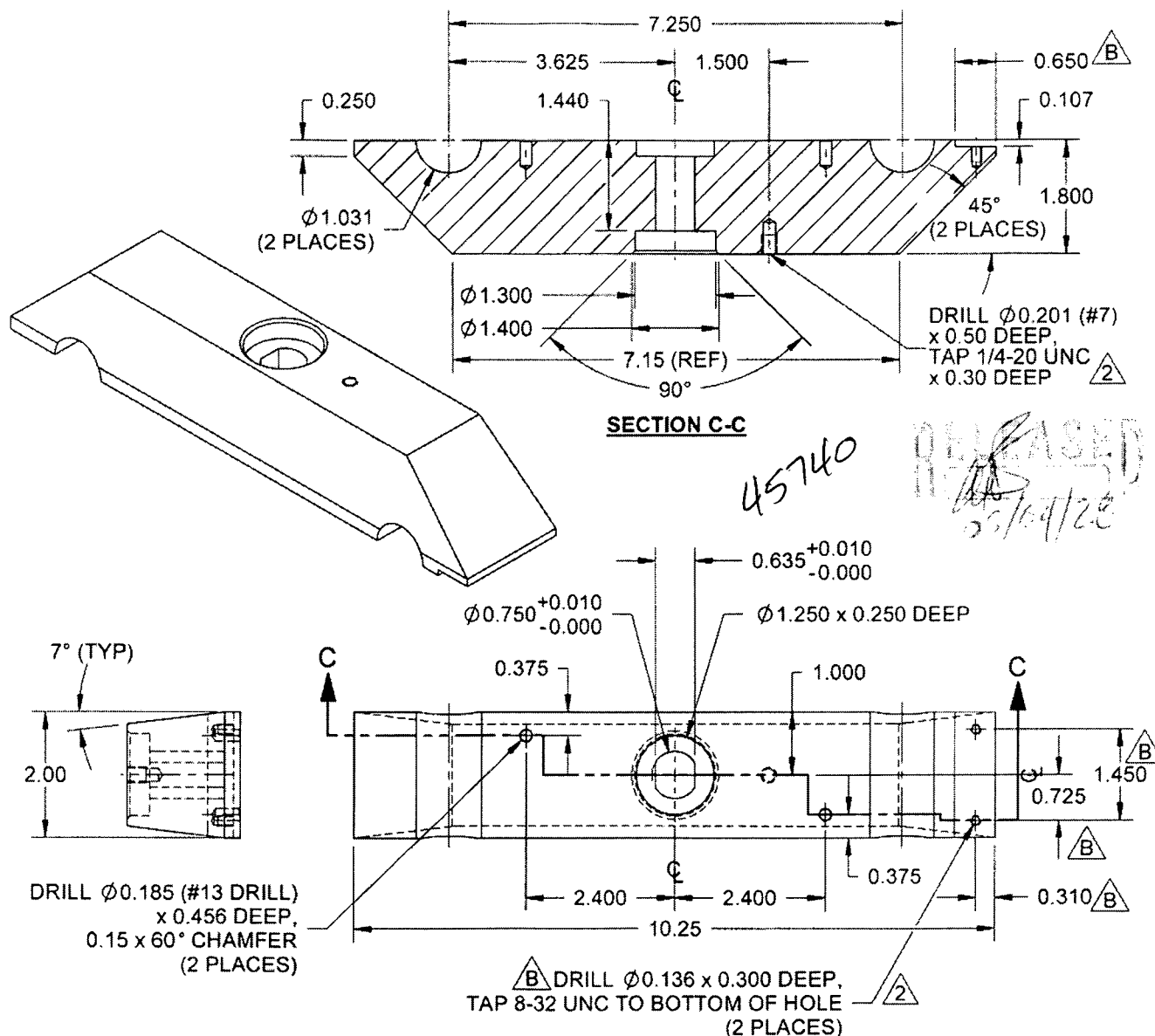
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5



D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

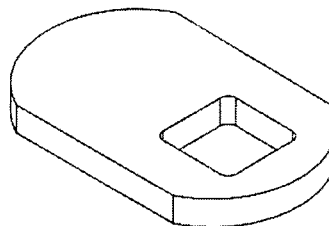
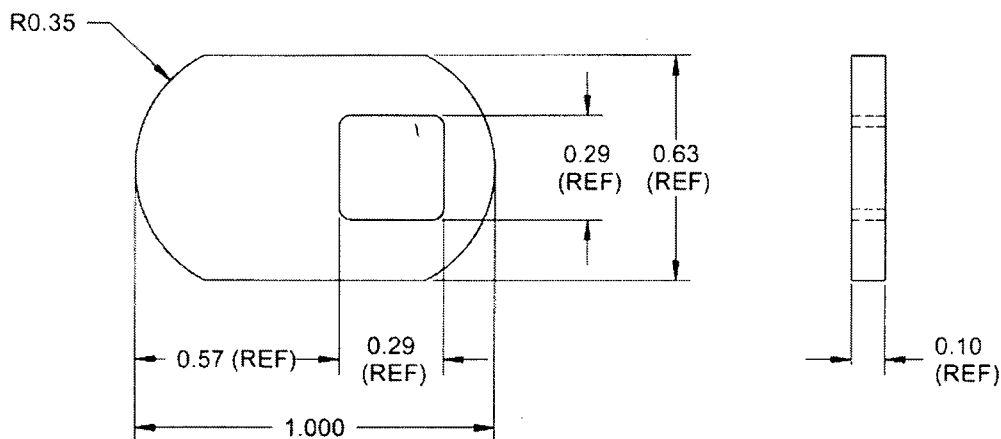
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 2:1

SPECIFICATION CONTROL DRAWING



45740

REFERENCE ONLY

D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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